

# Work Order ID 80365

\*80365\*

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Item ID: D3752-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Seat Frame  
 Start Date: 17/02/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 02/03/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/12 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3752	Rev C								

100 0.00  
 \*100\*  
 HandThermo Memo 0.00  
 Hand Finishing Thermoforming Cut sheet to required size  
 x4 OK  
 12/02/23

105 0.00  
 \*105\*  
 HandThermo Dry Material Memo 0.00  
 Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE  
 Temp: 240°F  
 Time IN: 7:00 pm 12/02/22  
 Time OUT: 6:00 am 12/02/23  
 x4 OK  
 12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

**Start Date:** 17/02/2012    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 02/03/2012      **Req'd Qty:** 4.00      **\* / \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*110\***

0.00

Thermoform

### Thermoforming Machine

## Memo

Thermoform as per Dwg. D3752 and folio (FTA022 ) using tool DT 8997

Dwg. Rev. C  
Folio Rev. C

0.00

**\*120\***

0.00

QC

## Quality Control

## Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*130\***

0.00

QC

## Quality Control

## Memo

QC8- Inspect parts - second check

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*80365\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*4\***

**Cust Item ID:**

**\*4\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**      **Date:**      **Tooling:**      **Date:**

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

**\*140\***

0.00

HandThermo

## Memo

### Hand Finishing Thermoforming

### 1) Trim to Finished Dimensions

150

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*150\***

0.00

OC

## Memo

## Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

0.00

OC

## Memo

## Quality Control

# Dart Aerospace Ltd

W/O:		80365 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 37527 PAR #: \_\_\_\_\_ Fault Category: Hermulung NCR: Yes No DQA: AK Date: 12/03/23  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/3/23

NCR: 12-1278		186.71 WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/16	150	Accidentally hit with saw blade. Scratch too deep to remove. Pl. operator error	S QS2412 12/03/16	Scrap x1 part No Reverb	12/03/16 Wh.	S 12/03/16	S QS2412 12/03/16	S 12/03/16

NOTE: Date & initial all entries

Work Order ID 80365

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Item ID: D3752-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Seat Frame  
 Start Date: 17/02/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 02/03/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>252A</u>	0.00							
*170*									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

12/27/12 (3)

12/3/20 4J

1203-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 80365

\*80365\*

Parent Item: D3752-1

\*D3752-1\*

Parent Item Name: Seat Frame

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD  
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C  
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105  
Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,620.620	10.667	42.668			

\*MI FXS 125-F60029-04\*

GE PLASTICS LEXAN SHEET

\*\*

Location

Loc Qty

Loc Code

MAT019

1620.62

119937

1620.62

42.668 sf H

12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	80365
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: JK Date: 12/02/23

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.048"	✓		ULTRA	
0.035	Min	0.059"	✓		ULTRA	
0.040	Min	0.085"	✓		ULTRA	
0.075	Min	0.110	✓		ULTRA	
0.052	Min	0.091	✓		ULTRA	
0.021	Min	0.057	✓		Vern DL-02	
0.036	Min	0.061	✓		Vern DL-02	

Measured by: JK Date: 12/03/16

Audited by: S Date: 12/03/16

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	<u>[Signature]</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE. 0.028 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE. 0.035 MIN THICKNESS AT THIS LOCATION

0.040 MIN THICKNESS ALONG TOP EDGE

OPTIONAL TOOLING HOLE. 0.075 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE. 0.052 MIN THICKNESS AT THIS LOCATION

HEAVY HAIRCELL TEXTURE ON THIS SIDE

0.021 MIN THICKNESS IN THIS AREA (CORNER)

0.036 MIN THICKNESS ALONG BOTTOM EDGE

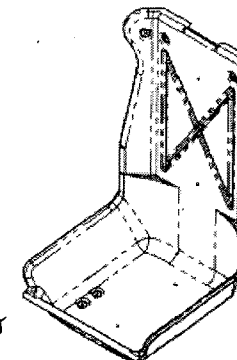
# D3752-1 SEAT FRAME

## NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

UNCOM  
SUBC

WILL  
WILL  
NO. 80365 M.C.J  
12/02/17



RELEASED  
08/11/05

C	REDUCE THICKNESS: 0.040 WAS 0.050 (ZB C8-1), 0.075 WAS 0.100 (C8-1), 0.092 WAS 0.090 (B8-1), 0.021 WAS 0.030 (B8-1), 0.038 WAS 0.060 (A8-1), 0.028 WAS 0.035 (D8-1), 0.035 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D8-1).	CP	08.10.05
H	FRONT PORTION NOW SHORTER (B5-1). 18.8 WAS 19.8 (C4-1). 31.5 WAS 31.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1).	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3752  
TITLE  
SEAT FRAME  
REV. C  
SHEET 1 OF 1  
SCALE  
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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